



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3210-1
Job Sheet 172805



Part No: D3210-1

Job Qty: 6 ea

Part Name: Doubler For Interior Window -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A New Issue 05-11-17 JLM IPP Rev:B Now On Waterjet 06-10-24 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		3/8/18	0.00	0.00	Start Up Waterjet		SC 18/03/18
100	Waterjet	6 pcs		3/8/18	0.00	1.44	Waterjet1		SC 18/03/18
120	QC	6 pcs		3/8/18	0.00	0.00	QC8		38
130	Small Fab	6 pcs		3/8/18	0.00	0.00	Small Fab-3		38
140	QC	6 pcs		3/8/18	0.00	0.00	QC5		38
150	HandFinish	6 pcs		3/8/18	0.00	0.41	HandFinish1		SA 18-3-15
155	QC	6 pcs		3/8/18	0.00	0.00	QC7-2		18-3-19
160	Powdercoat	6 pcs		3/9/18	0.00	0.19	Powdercoat4		18-3-19
170	QC	6 pcs		3/9/18	0.00	0.00	QC3		38
180	Packaging	6 pcs		3/9/18	0.00	0.00	Packaging3-1		9-38
190	QC21-SA	6 Ea		3/9/18	0.00	0.00	QC21		APR 03 2018

Part Op 100 - 1-Cut as per Dwg D3210

Descriptions: 130 - Debur

160 - START TIME:

8:50 CUT 320° FINISH: 9:00 - M13800

DAS
21
3-38

APR 03 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	10.2000 sf (1.7 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.080	10	15	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.141inches	+ 0.005 - 0.000	0.146 0.141	0.141
2	Doubler	0.128inches	+ 0.005 - 0.000	0.133 0.128	0.129
3	Doubler	3.857inches ± 0.010	3.867 3.847	3.860	
4	Doubler	17.750inches ± 0.010	17.760 17.740	17.753	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____ IQTV Effective : _____ 3 (QSI042) Approval

Description Work Order Device

DART AEROSPACE
 Container No: S049865
 Part: D3210-1
 Job No: 172805
 Revision: _____
 Serial No/Batch: S049865
 Inspector: _____
 Date: 03/10/18
 DART Aerospace Ltd.
 1270 Aberdeen Street
 Newbury, ON K4B 1K7
 CANADA
 TEL: 1 513 632-6200
 Email: sales@dartero.com
 www.dartaerospace.com

Completed By

hand / Supervisor
Approval Verification

QA Coordinator
Approval

Root Cause					
Environment	☐	No Re-verification	☐	Pressure/	☐
Design	☐	Operator	☐	Bending	☐
Doc/Data	☐	Offset/Setup	☐	Centre Nc	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐
Handling/Pre	☐	Training	☐	Crimp/Kink, kink, wave	☐
Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	☐

igned Wrong
 ide Dimensions
 /Under tolerance
 ract Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

5	Doubler	20.150inches $\pm$ 0.030	20.180 20.120	20,152
6	Doubler	8.500inches $\pm$ 0.010	8.510 8.490	8,501
7	Doubler	1.095inches $\pm$ 0.010	1.105 1.085	1,097
8	Doubler	0.650inches $\pm$ 0.010	0.660 0.640	0,654
9	Doubler	0.350inches $\pm$ 0.010	0.360 0.340	0,352

Plex 2/22/18 6:07 AM Dart.lajeunesse.marie

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
Part No. _____				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval _____		
Description Work Order Deviation				Disposition				Completed By _____	
								Lead hand / Supervisor Approval Verification _____	
								QC / QA Coordinator Approval _____	
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence							
OTHER : _____									